

D6104-011

AMOD
Page 1

Work Order ID 149288

149288

Thursday, July 21, 2016 3:21:05 PM

Item ID: DSK080

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: D2896-1 Turning Detail

Start Date: 7/13/2016 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 7/21/2016 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan:

DAS

21

9-89

Date: JUL 22 2016

Cooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK080

Rev A

100

100

Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.33

Turn blank as per Folio FA167
ENSURE TO TEST FIT ID BORE WITH 4TH AXIS PLUG /FIT MUST
SNUG****

DAS

45

9-89

2016-9-1

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.02

DAS

45

9-89

2016-9-15

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.02

DAS

14

9-89

16/09/18

Work Order ID 149288

Thursday, July 21, 2016 3:21:05 PM

149288

Page 2

Item ID: DSK080

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2896-1 Turning Detail

Start Date: 7/13/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/21/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.02

LOCATION: MAT060

DAS
14
9-89

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.08

DAS
21
9-89

SEP 19 2016

DAS
21
9-89

SEP 19 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Thursday, July 21, 2016 3:21:05 PM

Page 1

Work Order ID: 149288

Parent Item: DSK080

Parent Item Name: D2896-1 Turning Detail

149288
DSK080

Start Date: 7/13/2016

Required Date: 7/21/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	36.0000	1	5			

D6104-011

17-4 SS Roundbar 6.50"OD

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT043	36	
139232	1	
<u>143414</u>	3	
<u>144958</u>	10	
145266	10	
148652	12	

3
82
5

DAS
45
9-89 2016-09-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

DART AEROSPACE LTD		Work Order: 149288
Description: Turning Detail for D2896-1		Part Number: DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.484	3.482	3.481	2.481	2.482
B	3.990	4.010		3.999	3.999	3.999	3.998	4.000
C	3.825	3.845		3.835	3.834	3.832	3.832	3.832
D	0.718	0.738		0.727	0.727	0.728	0.728	0.728
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	3.705	3.725		3.712	3.712	3.711	3.711	3.711
G	1.360	1.380		1.370	1.371	1.370	1.370	1.370
H	1.250	1.260		1.254	1.254	1.254	1.254	1.256
I	6.490	6.510		6.495	6.495	6.495	6.496	6.496
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.240	0.260		0.260	0.260	0.260	0.260	0.260
L	0.107	0.127		0.114	0.116	0.115	0.114	0.115
M								
N								
O								
P								

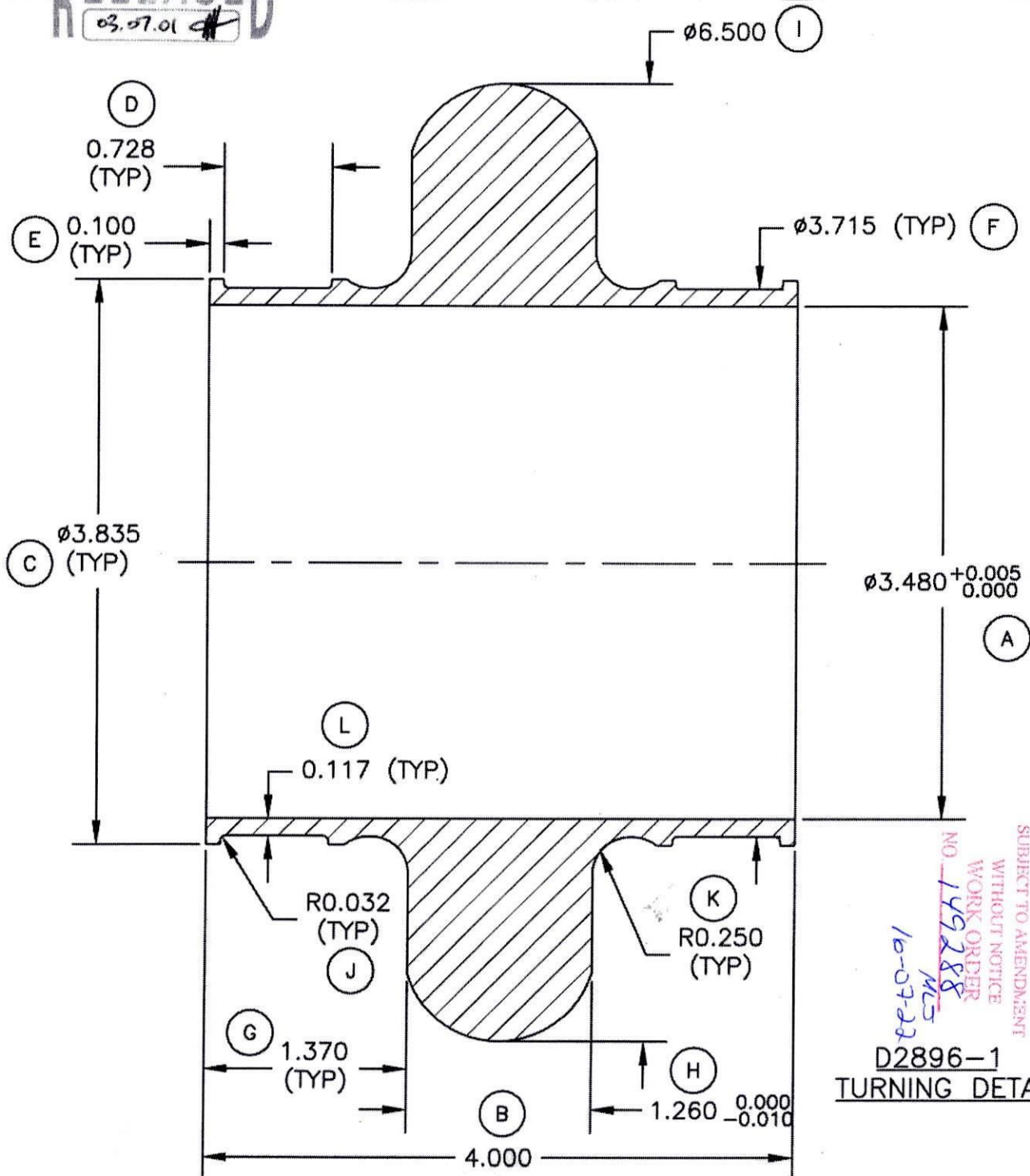
Measured by: DAS 45 9-89	Date: 2006-9-17
Audited by: DAS 14 9-89	Date: 16/09/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 149288
16-07-22
D2896-1
TURNING DETAIL

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.